

Date: Friday, 29/05/2009 3:46:15 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b>	: CU-DAR001 Dart Helicopters Services		<b>Drawing Name</b>	: BASKET BASE ASSEMBLY (350)		
<b>Job Number</b>	: 48298C			<b>Part Number</b>	: D2221	
<b>Estimate Number</b>	: 10189			<b>Drawing Number</b>	: D2221 REV H	
<b>P.O. Number</b>	:			<b>Project Number</b>	: N/A	
<b>This Issue</b>	: 29/05/2009	<b>S.O. No.</b>	: :	<b>Drawing Revision</b>	: H	
<b>Prsht Rev.</b>	: NC			<b>Material</b>	:	
<b>First Issue</b>	: 29/05/2009	<b>Type</b>	: LARGE FAB ASSY	<b>Due Date</b>	: 08/06/2009	<b>Qty:</b> 1 <b>Um:</b> Each
<b>Previous Run</b>	: 48096A					
<b>Written By</b>	:					
<b>Checked &amp; Approved By</b>	: <u>JUL 09.05.29</u>					
<b>Comment</b>	: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM Est Rev:K 08-08-29 revG as per dwg DD verified by:EC Est Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC Est Rev:M 08-12-02 revH as per dwg DD verified by:					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D22211	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B48101</u>	PD 09.06.09
2.0	D22215	Rib	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib batch: <u>B46768</u>	PD 09.06.09
3.0	D22217	Rib	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib batch: <u>B2221 B46566</u>	PD 09.06.09
4.0	D22323	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Hinge batch: <u>B46822 -&gt;1 B46949 -&gt;1</u>	PD 09.06.09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: BASKET BASE ASSEMBLY (350)
Job Number:	48298C	Part Number: D2221
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D22351 	Basket Rib 
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Basket Rib batch: B48319
		PD 09.06.09
6.0	D2581 	Mounting Bracket
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mounting Bracket batch: B47264
		PD 09.06.09
7.0	D34421 	Shim
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Shim batch: B46809
		PD 09.06.09
8.0	D3825041 	Rib Assembly (Basket End)
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib Assembly (Basket End) batch: B47055
		PD 09.06.09
9.0	D3826041 	Rib / Gusset Assembly
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Rib / Gusset Assembly batch: B47571
		PD 09.06.09
10.0	D3827041 	Rib Assembly (Inboard)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Rib Assembly (Inboard) batch: B416476
		PD 09.06.09
11.0	D38331 	Mesh (Base End Face)
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s) Mesh (Base End Face) batch: B48217
		PD 09.06.11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 48298C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

12.0 D38321 Mesh (Base)



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Mesh (Base)

batch: B48332

PD 09.06.11

13.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221

2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221

3- tack weld mesh on basket as per dwg D2221

A/R ER316 S.S. Rod Batch: M108160

PD 09.06.11

14.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09.06.15

15.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

309.06.15 R

16.0 POWDER COATING POWDER COATING



M111472

Comment: POWDER COATING

1- Plug holes prior to powder coating

2-Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME: 10:00 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 10:30 AM

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME: 11:00 AM

OVEN TEMPERATURE: 400°F

FINISH TIME: 11:30 AM

JH 09-06-15 CX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Job Number: 48298C

Part Number: D2221

Job Number:



Seq. #: Machine Or Operation:

Description :

17.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



BR 09-06-17

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

18.0 QC21

FINAL INSPECTION/W/O RELEASE



09/06/18 JG

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF  
09-06-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED  
08/11/18 NED

**D2221 BASKET BASE ASSEMBLY (AS350)**  
(MESH SHOWN LOCALLY FOR CLARITY)

**H**

REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1). REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3625-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1-0; INBOARD SHIM ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.

**G**

MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS TO BE REMOVED. NOTE: TRANSFERRED FROM SHT 1 TO SHT 2. SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERED TO "B" FORMAT

**F**

ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET

**E**

CHANGE HINGE

**D**

CHANGE LATCH

**C**

SEPARATE BASKET AND LID

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 42.00 lbs APPROX
- 8) MASK ALL HOLES PRIOR TO POWDER COATING

NO. *WJ8286C*

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**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

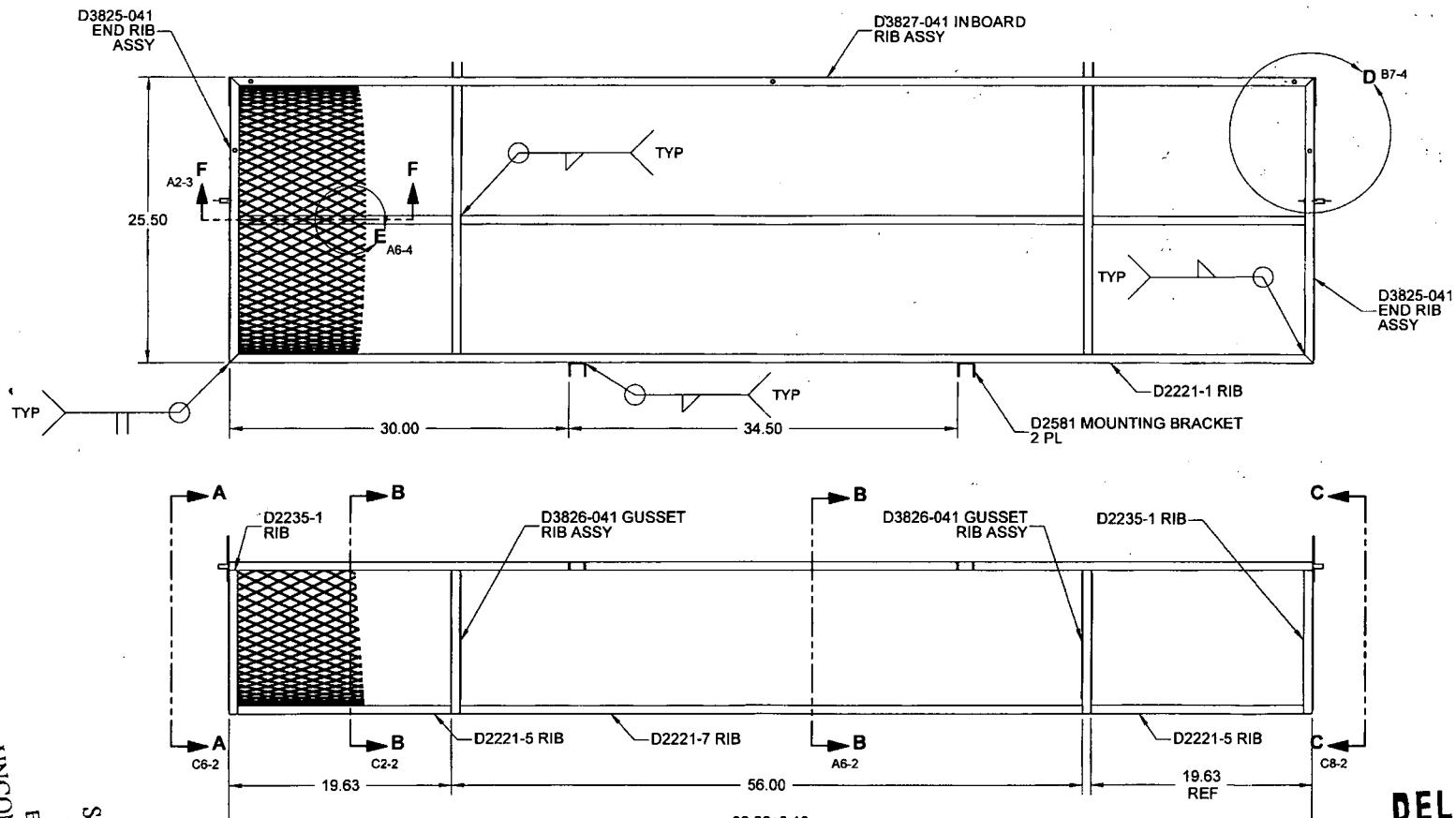
**DRAWING NO.** *D2221* **REV. H**  
**SHEET 1 OF 5**

**TITLE** **SCALE**  
**BASKET BASE ASSEMBLY (350)** **NTS**

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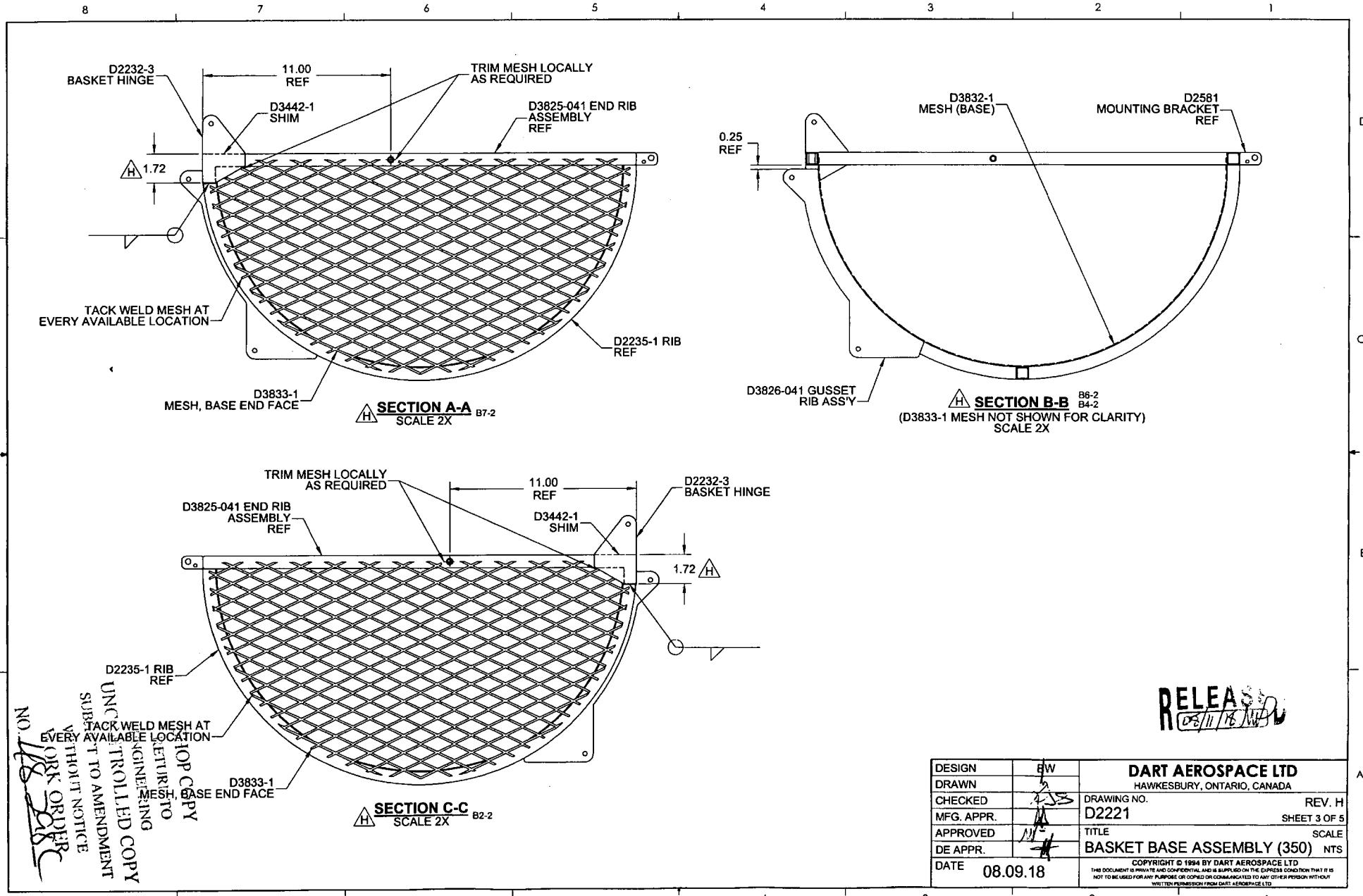


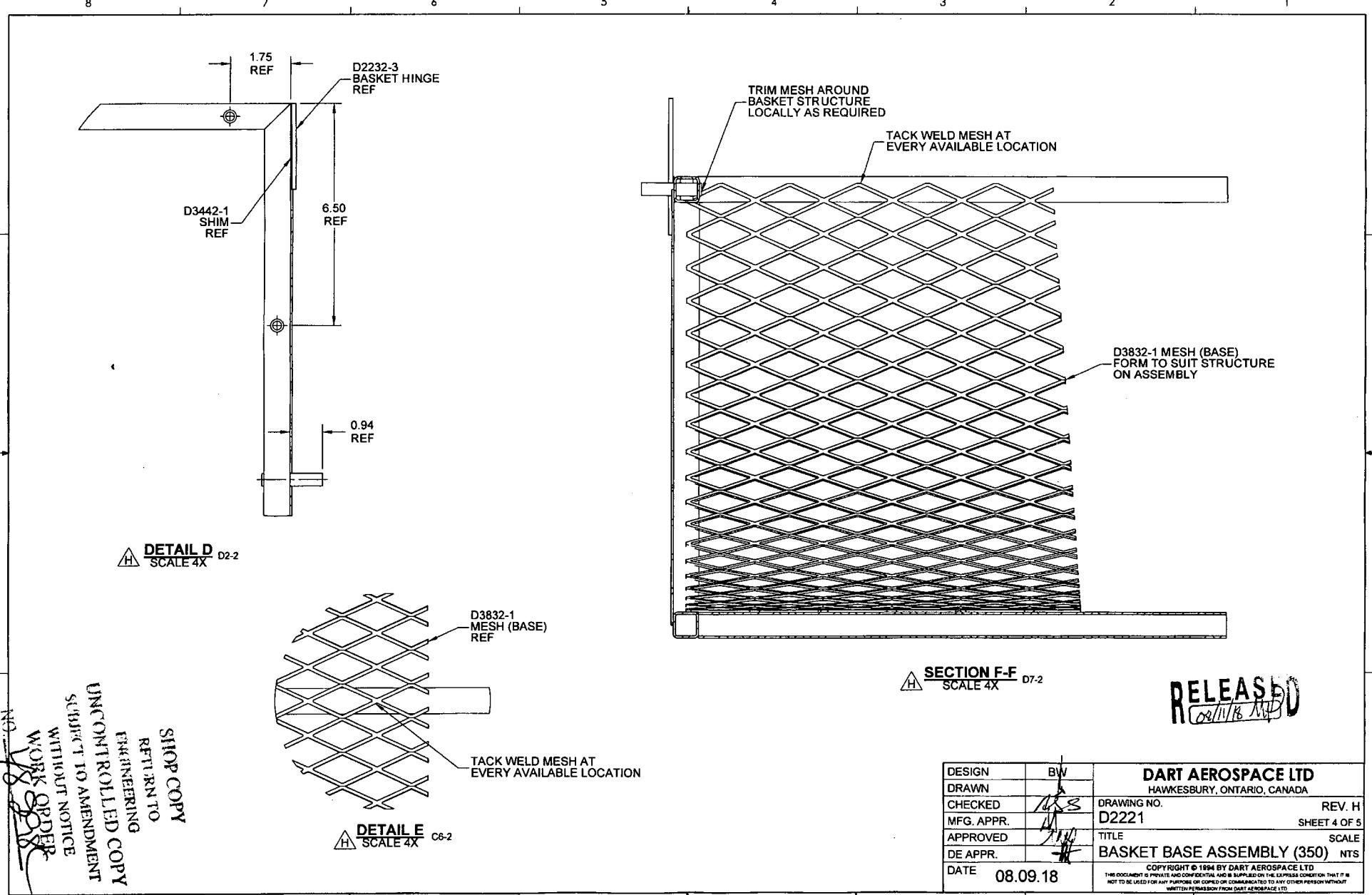
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(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
08/11/18 NWD

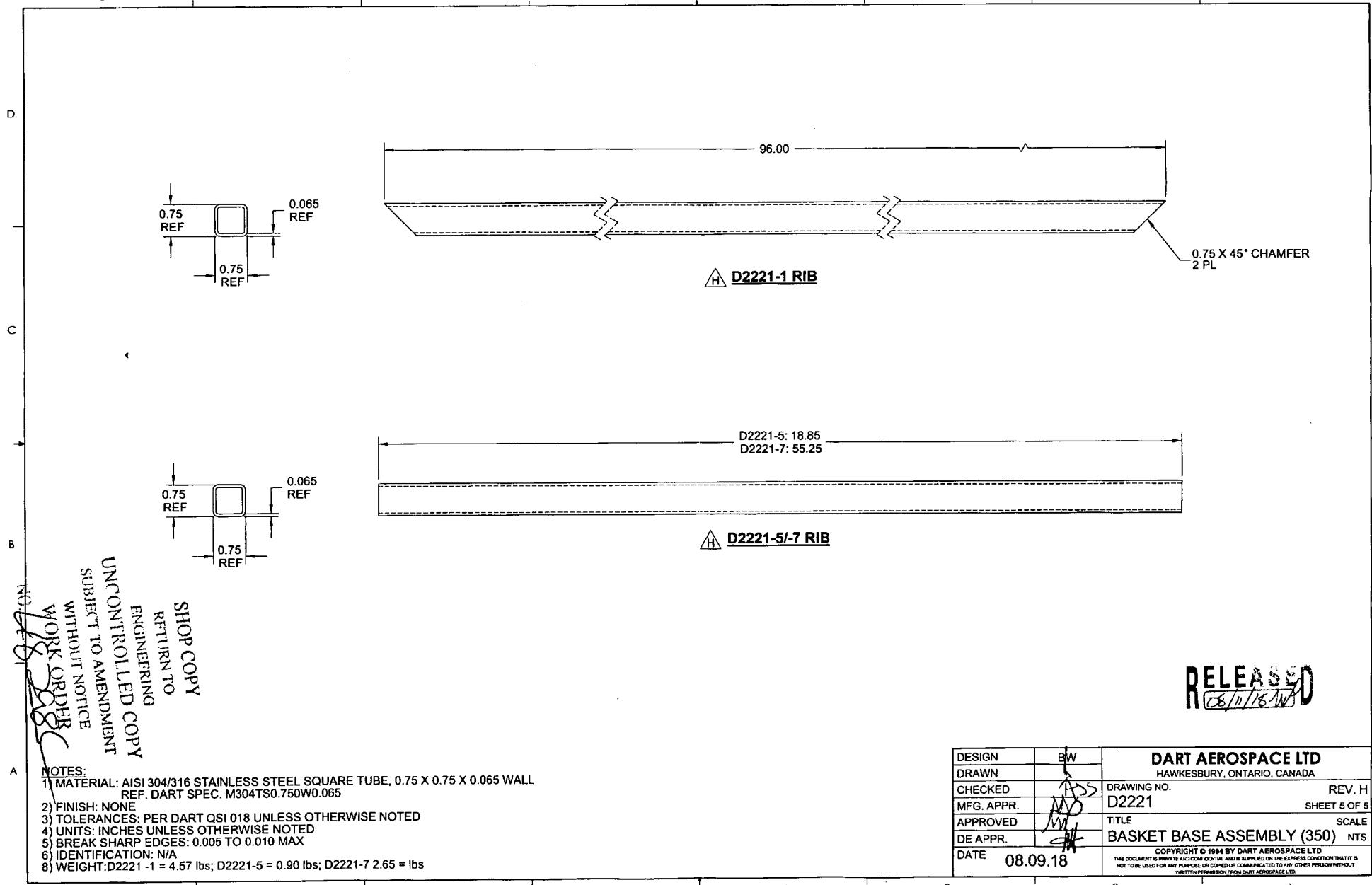
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CHECKED	<i>JAS</i>	DRAWING NO.	REV. H	
MFG. APPR.	<i>JAS</i>	D2221	SHEET 2 OF 5	
APPROVED	<i>JAS</i>	TITLE	SCALE	
DE APPR.	<i>JAS</i>	BASKET BASE ASSEMBLY (350) NTS		
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8 7 6 5 4 3 2 1



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